

Work Order ID 117309

June-16-14 10:54:42 AM

117309

Page 1

Item ID: D4869-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: End Fitting, Eye
 Start Date: 6/16/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 6/16/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference: PART MARKING

Approvals: Process Plan: MLJ Date: 1406-16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4869	rev a

105 0.00
105
 Purchasing
 Purchasing
 Memo
 PULL FROM STK:
 2 X D4869-1 B116167
 SEND TO P & L PRINTING FOR PART MARKING
 PO 24622

108 0.00
108
 Packaging
 Packaging
 Receive & Inspect for Damage & Mat'l Certs
 Memo 0.00

110 0.00
110
 QC
 Quality Control
 QC6- Inspect dimensions to drawing
 Memo 0.00

N/A already engaged on H&S

CL 14/06/17

P 4/4/18 E

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/16/14 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 6/16/14 **Req'd Qty:** 2.00 ***~***

Customer:

Reference: PART MARKING

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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115

Identify as per dwg & Stock Location:

0.00

115

Packaging

Memo

0.00

Packaging

RE-IDENTIFY USING NEW B/N

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

W 14-06-20

~~1~~

Picklist Print

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Work Order ID: 117309

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Parent Item: D4869-1

D4869-1

Parent Item Name: End Fitting, Eye

Start Date: 6/16/14

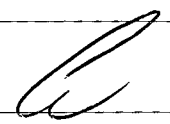
Required Date: 6/16/14

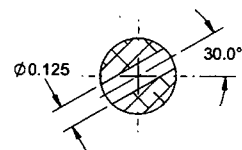
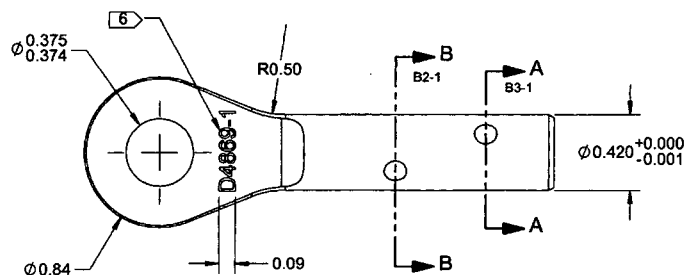
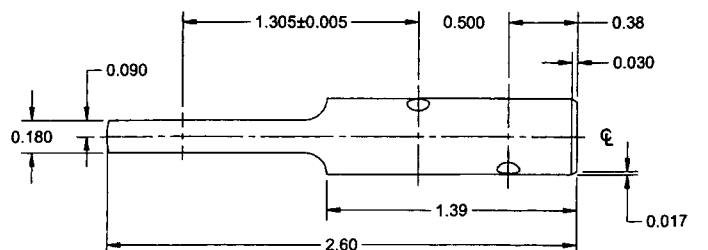
Start Qty: 2.00

Required Qty: 2.00

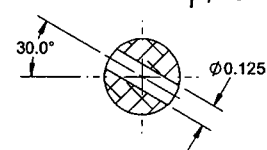
Comments: IPP REV:A NEW ISSUE 14-01-16 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4869-1		Manufactured	No				Each	0.0000		2			
D4869-1									**				
End Fitting, Eye													

516167 



SECTION A-A C5-1



SECTION B-B C6-1

D4869-1 END FITTING, EYE

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3.
ENGRAVE P/N USING 0.09 HIGH LETTERS TO A MAX. DEPTH OF 0.010
- 7) WEIGHT: 0.08 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

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WORK ORDER

NO. 117309 MLS
1406-16

A	NEW ISSUE			RF	13.09.16
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			REV. A
DRAWN	RF				
CHECKED	HS	DRAWING NO.	SHEET 1 OF 2		
MFG. APPR.	JLM	D4869	SCALE		
APPROVED	HS	TITLE	SCALE		
DE APPR.	DS	END FITTING	NTS		
DATE	13.12.16	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			